ORDER NO. HAD8604464C9

Service Manual

DC Servo Automatic
Turntable System

Turntable System

SL-JS16R

or

) ..... Black Type

Areas

[E] ..... Switzerland and Scandinavia.
[EK] .... United Kingdom.
[EG] ... F.R. Germany.
[EB] .... Belgium.
[EH] .... Holland.
[EF] .... France.
[Ei] ..... Italy.
[XA] .... Southeast Asia, Oceania, Africa, Middle Near East and Central South America.
[PC] .... European Audio Club.

T4P is the standard mark for plug-in-connector system. Products carrying this mark are interchangeable and compatible with each other.

SPECIFICATIONS

■ Turntable section

Type:	Automatic turntable
Features:	Auto-return Auto-start Auto-stop Auto size select
Drive method:	Belt drive
Motor:	DC Motor
Drive control method:	DC servo control
Turntable platter:	Aluminum die-cast Diameter 300 mm
Turntable speeds:	33-1/3 rpm and 45 rpm
Wow and flutter:	0.045% WRMS (JIS C5521) ±0.06% peak (IEC 98A weighted)
Rumble:	−70 dB DIN-B (IEC 98A weighted)

■ Tonearm section

Type:	Static-balanced, straight tonearm Plug-in-connector cartridge system
Overhang:	25 mm
Effective length:	200 mm
Tracking error angle:	Within 0°36' at outer groove of 30 cm disc Within 3°18' at inner groove of 30 cm disc
Stylus pressure:	1.25 g (Fixed)
Applicable cartridge weight:	6 g

■ Cartridge section

Type:	Moving magnet stereo cartridge
Magnet circuit:	All laminated core
Frequency response:	10 Hz~35 kHz
Output voltage: (LINE OUT)	150 mV at 1 kHz, 5 cm/s. zero to peak lateral velocity
Channel separation:	22 dB at 1 kHz
Channel balance:	Within 2 dB at 1 kHz
Recommended load impedance:	47 kΩ~100 kΩ
Compliance (dynamic):	12×10^{-6} cm/dyne (100 Hz)
Stylus pressure range:	1.25±0.25 g
Weight:	6 g (cartridge only)
Replacement stylus:	EPS-24CS

■ General

Power supply:	DC 12V
Power consumption:	1 W
Dimensions (W×H×D):	315×79×315 mm When dust cover is open: 315×380×315 mm
Weight:	2.3 kg

Specifications are subject to change without notice for further improvement.

Technics

Matsushita Electric Trading Co., Ltd.
P.O. Box 288, Central Osaka Japan

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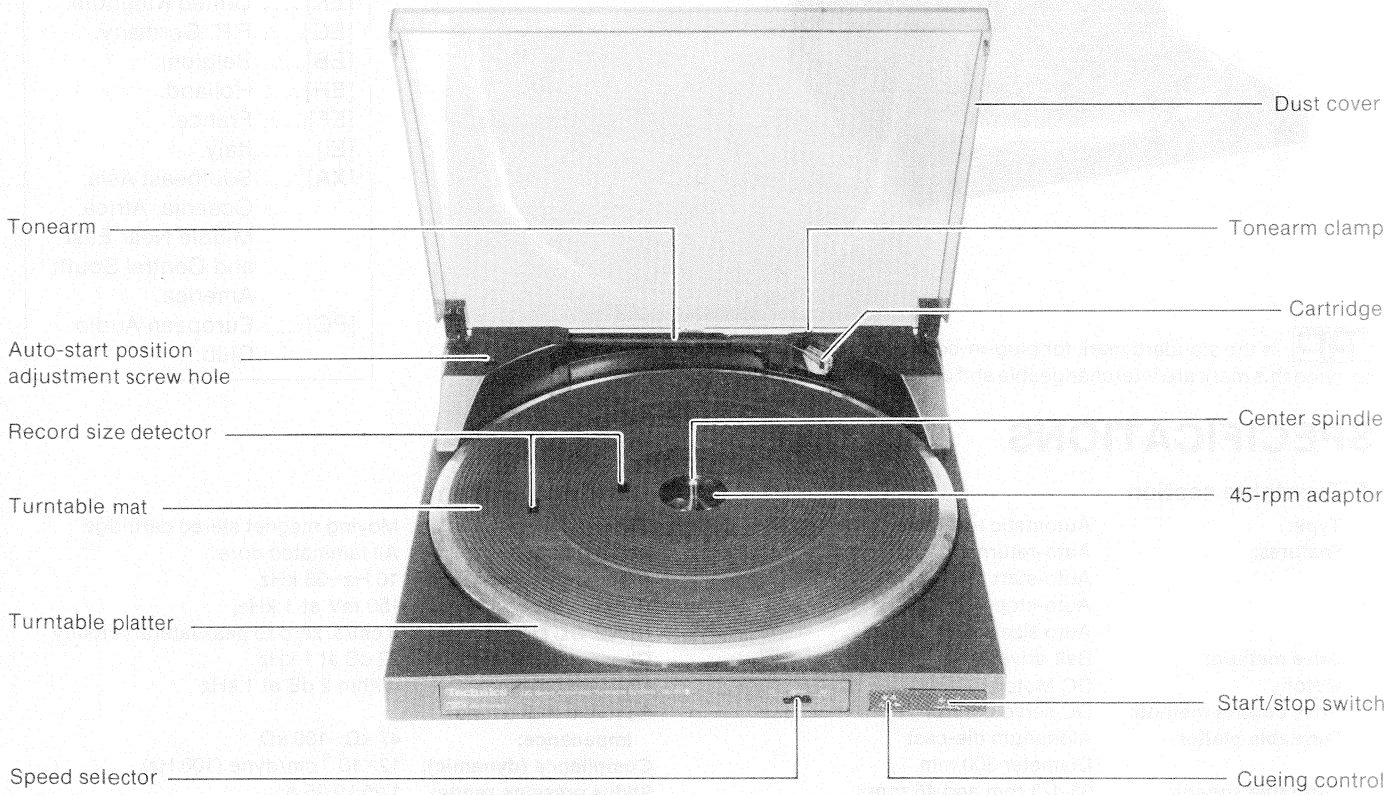
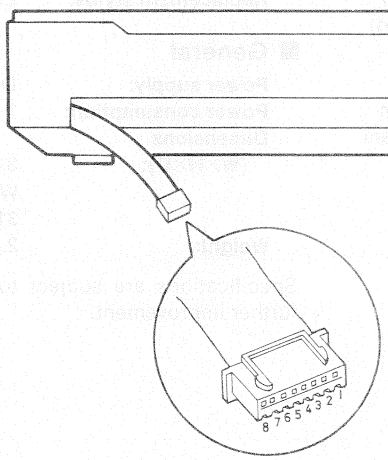
■ LOCATION OF CONTROLS





1. R ch. signal output
2. GND
3. L ch. signal output
4. GND
5. DC 12V input
6. SYNCHRO signal output
7. REMOTE signal input
8. NC

ORDER NO. HAD8604464C9-A

DC Servo Automatic Turntable System

SL-JS16R

DEUTSCH

■ MESSUNGEN UND JUSTIERUNGEN

AUTO-START-POSITION

1. Den Tonarm an der Tonarmablage-Position festklemmen. Tonarm leicht antippen, um zu prüfen, ob er sicher verriegelt ist.
2. Die Staubabdeckhabe abnehmen.
3. Falls der Tonarm außerhalb der Einlaufrille der platte aufsetzt, im Uhrzeigersinn drehen (IN). Falls er zu weit innen aufsetzt, entgegen dem Uhrzeigersinn drehen (OUT).

Vorsicht: Mit dem Schraubendreher nicht stark nach unten drücken.

4. Staubabdeckhaube wieder aufsetzen.

TONARMLIFTHÖHE

1. Die Staubabdeckhaube abnehmen.
2. Den Tonarm mit der Tonarmklemme befestigen.
3. Die Kappe vom Justierloch abnehmen.
4. Den Tonarmlift-Schalter auf (▽) stellen.
5. Eine Schallplatte auf die Plattentellerauflage legen.
6. Die Tonarmklemme verschieben, um den Tonarm freizustellen, und den Abstand zwischen Nadelspitze und Plattenoberfläche auf 4 mm - 7 mm einstellen.

DREHZAHL

1. Den Drehzahl-Wahlschalter auf "33" stellen.
2. Den Plattenspieler anheben und einen Schraubendreher von hinten in das Justierloch (33 UPM) einstecken, um VR101 zu drehen.
3. Den Drehzahl-Wahlschalter auf "45" stellen.
4. Gleich wie in Schritt 2 vorgehen: Schraubendreher in das Justierloch (45 UPM) einstecken, um VR102 zu drehen.

Anmerkung: Die Drehzahl-Justierung für 33-1/3 UPM sollte zuerst vorgenommen werden.

FRANÇAIS

■ MESURAGES ET REGLAGES

POSITION DE DEMARRAGE AUTOMATIQUE

1. Bloquer le bras de lecture à la position de repos. Frapper doucement sur le bras de lecture pour s'assurer qu'il est bloqué en place de façon sûre.
2. Retirer le couvercle protège-poussière.
3. Si le bras de lecture se dépose à l'extérieur du sillon d'entrée du disque, tourner dans le sens des aiguilles d'une montre ("IN"). S'il s'abaisse trop loin à l'intérieur du sillon d'entrée, tourner dans le sens inverse des aiguilles d'une montre ("OUT").

Nota: Ne pas appuyer trop fortement sur le tournevis.

4. Remettre en place le couvercle protège-poussière.

HAUTEUR D'ELEVATION DU BRAS

1. Retirer le couvercle protè-poussière.
2. Fixer le bras de lecture avec le clip de retenue du bras.
3. Retirer le capuchon de l'orifice de réglage.
4. Régler le commutateur de commande de pose/relevage sur (▽).
5. Placer un disque sur le tapis de la platine.
6. Déplacer le clip de retenue du bras pour laisser le bras de lecture libre, et régler l'intervalle entre l'extrémité de la pointe de lecture et la surface du disque sur 4 mm - 7 mm.

VITESSE DE ROTATION

1. Régler le commutateur du sélecteur de vitesse sur "33".
2. Soulever l'appareil et introduire à partir de l'arriére un tournevis dans l'orifice de réglage (33 t/p.m.) pour faire tourner VR101.
3. Régler le commutateur du sélecteur de vitesse sur "45".
4. Comme à l'étape 2, introduire un tournevis dans l'orifice de réglage (45 t/p.m.) et faire tourner VR102.

Nota: Le réglage de la vitesse devra s'opérer tout d'abord pour 33 t/p.m.

ESPAÑOL

■ MEDICIONES Y AJUSTE

POSICION DE ARRANQUE AUTOMATICO

1. Fijar el brazo de fonocaptor en la posición de descanso. Golpear ligeramente el brazo de fonocaptor para asegurarse de que está firmemente fijado en su lugar.
2. Remover la cubierta para el polvo.
3. Si el brazo de fonocaptor cae fuera del surco de entrada de disco, girar a la derecha (ENTRADA).
   Si el brazo de fonocaptor cae dentro del surco de entrada de disco, girar a la izquierda (SALIDA).

Nota: No apretar muy fuertemente sobre el destornillador.

4. Volver a colocar la cubierta para el polvo.

ALTURA DE ALZA DE BRAZO

1. Remover la cubierta para el polvo.
2. Asegurar el brazo de fonocaptor con un fijador de brazo.
3. Remover el tapón del agujero de ajuste.
4. Poner el interruptor de control de guía en (▽).
5. Colocar un disco sobre la esterilla del plato giradiscos.
6. Mover el fijador de brazo de fonocaptor para que éste quede libre, y ajustar la separación entre la punta de la aguja y la superficie a 4 mm — 7 mm.

VELOCIDAD ROTATIVA

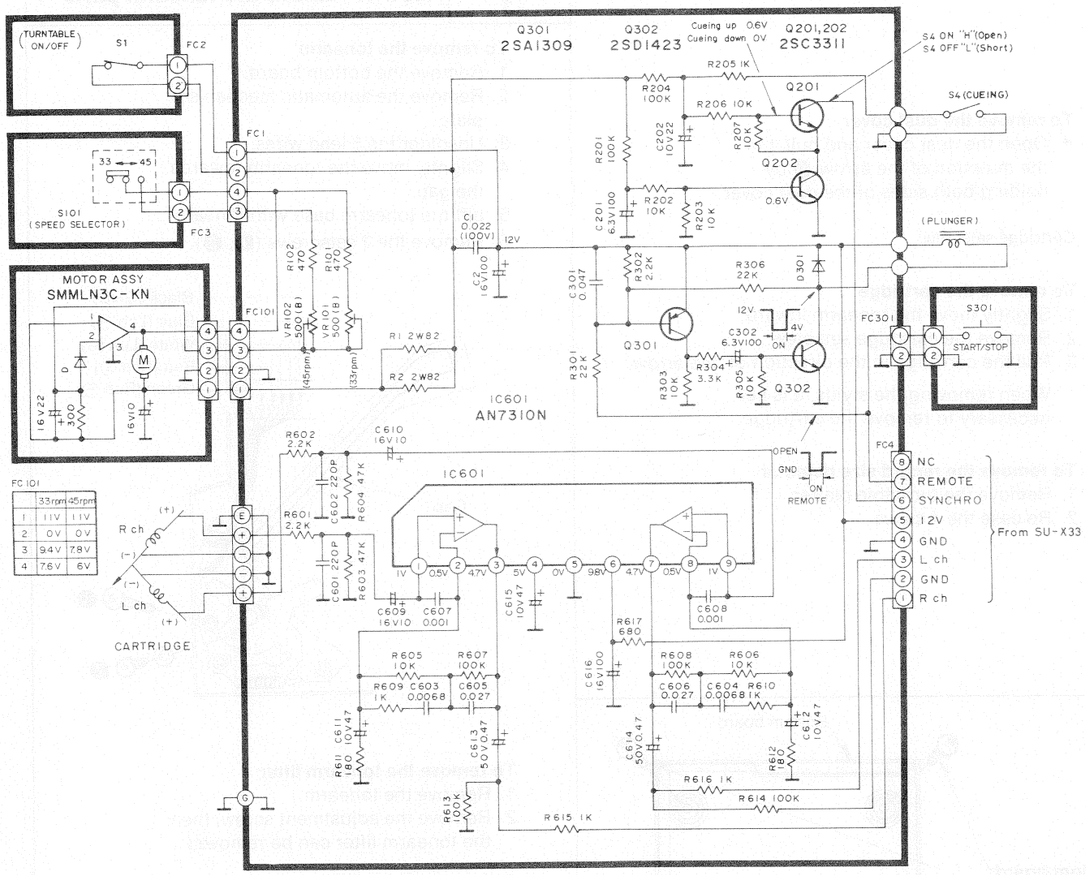
1. Poner el selector de velocidad en "33".
2. Levantar la unidad en insertar un destornillador dentro del agujero de ajuste (33-rpm) desde detrás para girar VR101.
3. Poner el selector de velocidad en "45".
4. Lo mismo que en el paso 2, insertar un destornillador dentro del agujero de ajuste (45-rpm) y girar VR102.

Nota: El ajuste de velocidad debe hacerse primero en 33-rpm.

Printed in Japa
860406000 Ⓢ A

■ SCHEMATIC DIAGRAM

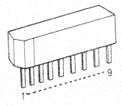
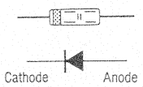
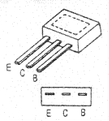
(This schematic diagram may be modified at any time with development of new technology.)



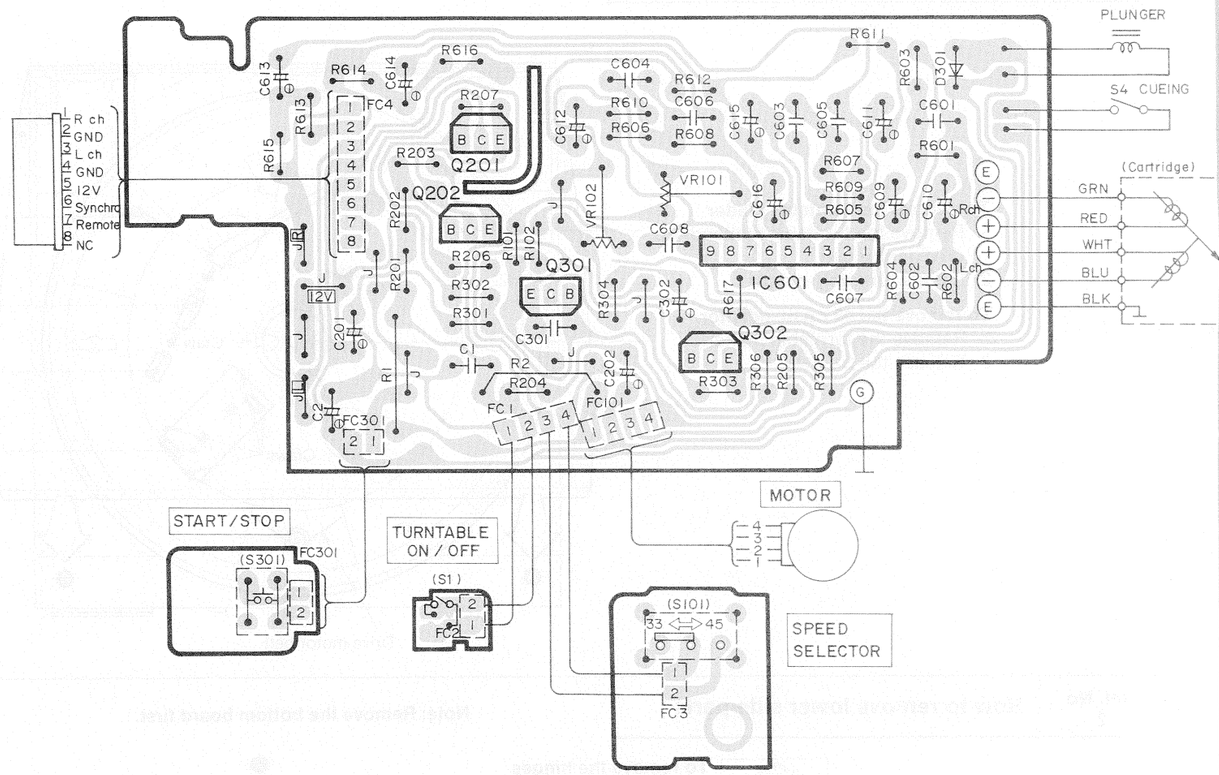
Notes:

1. S1 : Turntable (ON/OFF) switch in the "**on**" position.
2. S4 : Cueing control switch in the "**down**" position.
3. S101: Speed selector switch in the "**33 rpm**" position.
4. S301: START/STOP switch.
5. The values are of the reference voltage for the turntable rotation of this unit, measured by a DC voltmeter (high impedance) on the basis of chassis. So, some error might be included depending on the internal impedance of the measuring instrument and the unit measured.
6. Important safety notice:
   components identified by ⚠ mark have special characteristics important for safety.
   When replacing any of these components, use only manufacturer's specified parts.

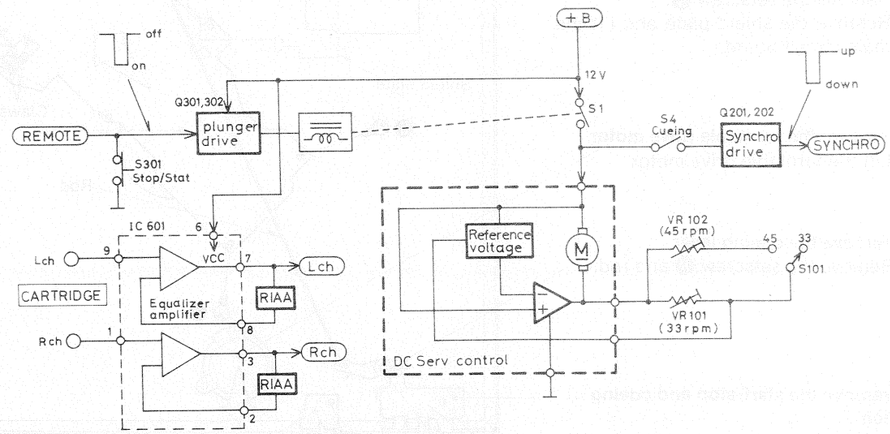
• Terminal guide of transistors, diode and IC's.

AN7310	SVD1SR35200V	2SD1423 2SC3311 2SA1309
		
	Cathode Anode	E C B / E C B

■ CIRCUIT BOARD AND WIRING CONNECTION DIAGRAM



• Block diagram

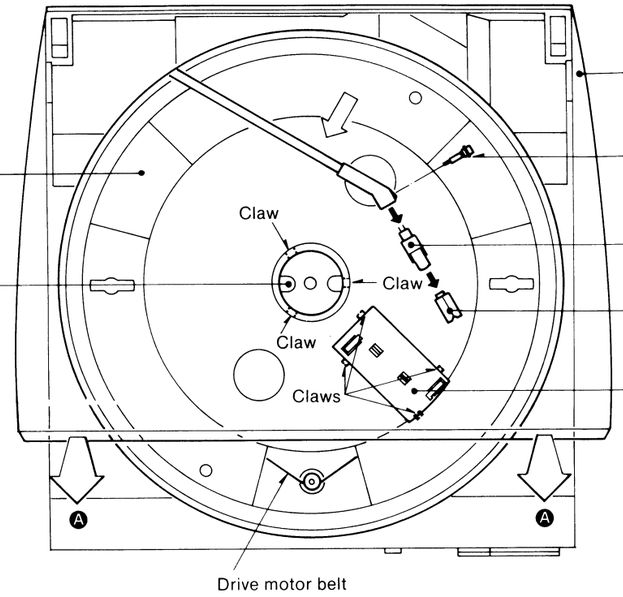


■ DISASSEMBLY INSTRUCTIONS

Ref. No. 1 — How to remove upper side parts

To remove the turntable platter
1. Remove the turntable mat and the drive motor belt.
2. Lift the turntable platter.

To remove the 45 r.p.m. adaptor
1. Remove the turntable platter.
2. Release the 3 claws.



To remove the dust cover
- Open the dust cover and pull it in the direction of the arrow Ⓐ by holding both sides of the dust cover.

Cartridge setscrew

To remove the cartridge
1. Slightly move the tonearm inward.
2. Remove the cartridge setscrew.
3. Pull the cartridge in the direction of the arrow.

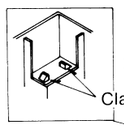
* When removing the stylus, it is not necessary to remove the cartridge.

To remove the record size detector
1. Remove the turntable platter.
2. Release the 4 claws.

Ref. No. 2 — How to remove lower side parts

Note: Remove the bottom board first.

To remove the hinges
1. Remove the dust cover.
2. Release the 2 claws.

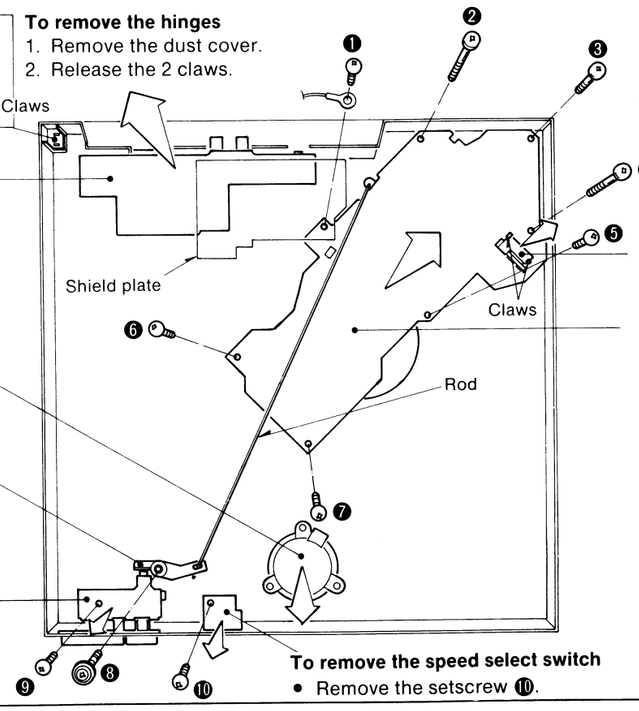


To remove the main circuit board
1. Remove the setscrew ❶.
2. Remove the shield plate and lift the main circuit board.

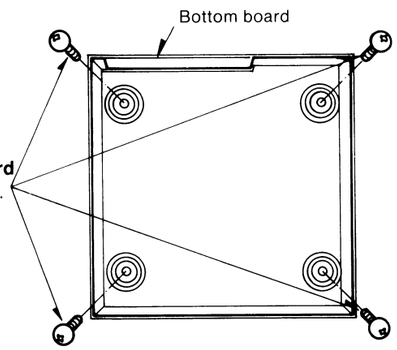
To remove the turntable drive motor
- Lift the turntable drive motor.

To remove the cueing lever
- Remove the setscrew ❽ and rod.

To remove the start/stop and cueing button
- Remove the setscrew ❾ and the button holder.



To remove the speed select switch
- Remove the setscrew ❿.



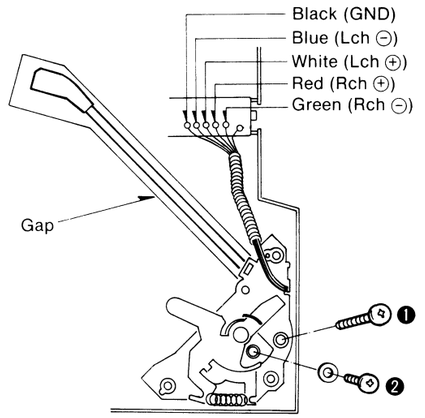
To remove the bottom board
- Remove the 4 setscrews.

To remove the switch
- Release the 2 claws.

To remove the automatic mechanism plate
1. Remove the 7 setscrews (❶~❼).
2. Remove the rod.

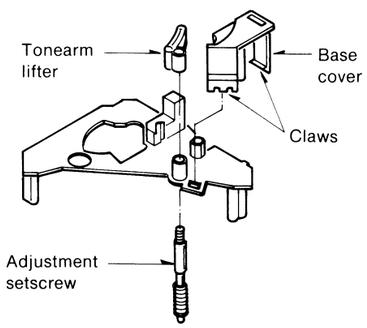
Ref. No. 3 — How to remove the tonearm parts

To remove the tonearm
1. Remove the bottom board.
2. Remove the automatic mechanism plate.
3. Unsolder the 5 lead wires.
4. Slightly move the tonearm towards the gap.
5. Lift the tonearm base with tonearm.
6. Remove the 2 setscrews (❶, ❷).



To remove the tonearm lifter
1. Remove the tonearm.
2. Remove the adjustment screw, then the tonearm lifter can be removed.

To remove the base cover
1. Remove the tonearm.
2. Release the 2 claws.



Note: When removing the tonearm lifter and the base cover, it is not necessary to remove the 5 lead wires.

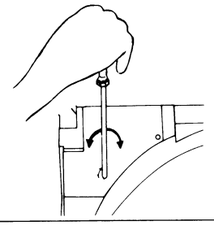
■ MEASUREMENTS AND ADJUSTMENTS

AUTO-START POSITION

1. Clamp tonearm at rest position. Lightly tap tonearm to make sure it is securely clamped in place.
2. Remove the dust cover.
3. If tonearm sets down outside of record's lead-in groove, turn clockwise (IN). If it sets down to the far inside lead-in groove, turn counterclockwise (OUT).

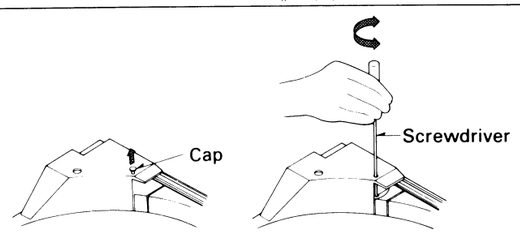
Note: Do not push down very strongly on screwdriver.

4. Replace dust cover.



TONEARM LIFT HEIGHT

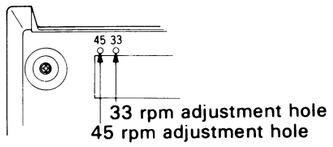
1. Remove the dust cover.
2. Secure the tonearm with arm clamper.
3. Remove the cap from the adjusting hole.
4. Set the cueing control switch to "▼".
5. Put a record on the turntable mat.
6. Shift the arm clamper to set the tonearm free, and adjust the gap between stylus tip and record surface to 4mm~7mm.



ROTATING SPEED

1. Set the speed selector switch to "33".
2. Raise the unit and insert a screwdriver into the adjusting hole (33-rpm) from the back to turn VR101.
3. Set the speed selector switch to "45".
4. Same as in step 2, insert a screwdriver into the adjusting hole (45-rpm) and turn VR102.

Note: The speed adjustment should be done in 33-rpm first.



■ REPLACEMENT PARTS LIST

Notes: 1. Part numbers are indicated on most mechanical parts. Please use this part number for parts orders.
2. Important safety notice: Components identified by ⚠ mark have special characteristics important for safety. When replacing any of these components, use only manufacturer's specified parts.
3. Bracketed indications in Ref. No. columns specify the area. Parts without these indications can be used for all areas.

Areas

[E] ..... Switzerland and Scandinavia.
[EK].... United Kingdom.
[EG] ... F.R. Germany.
[EB].... Belgium.
[EH].... Holland.
[EF] .... France.
[Ei]..... Italy.
[XA].... Southeast Asia, Oceania, Africa, Middle Near East and Central South America.
[PC].... European Audio Club.

Ref. No.	Part. No.	Description
INTEGRATED CIRCUIT		
IC601	AN7310	Integrated Circuit
TRANSISTORS		
Q201, 202	2SC3311	Transistor
Q301	2SA1309	Transistor
Q302	2SD1423	Transistor
DIODE		
D301	SVD1SR35200V	Diode
VARIABLE RESISTORS		
VR101, 102	EVN61AA00B52	500Ω (B)

Ref. No.	Part. No.	Description
SWITCHES		
S1	SFDSD72R01	Turntable on/off
S3	SSHB2	Cueing (Mechanical)
S4	SRDSBSW-180	Cueing (Electrical)
S101	SSSB3	Speed Selector
S301	EVQQS205K	Start/Stop
RESISTORS		
R1, 2	ERG2SJ820	Metal Oxide, 2W, 82Ω, ±5%
R101, 102	ERDS2TJ471	Carbon, 1/4W, 470Ω, ±5%
R201	ERDS2TJ104	Carbon, 1/4W, 100kΩ, ±5%
R202, 203	ERDS2TJ103	Carbon, 1/4W, 10kΩ, ±5%

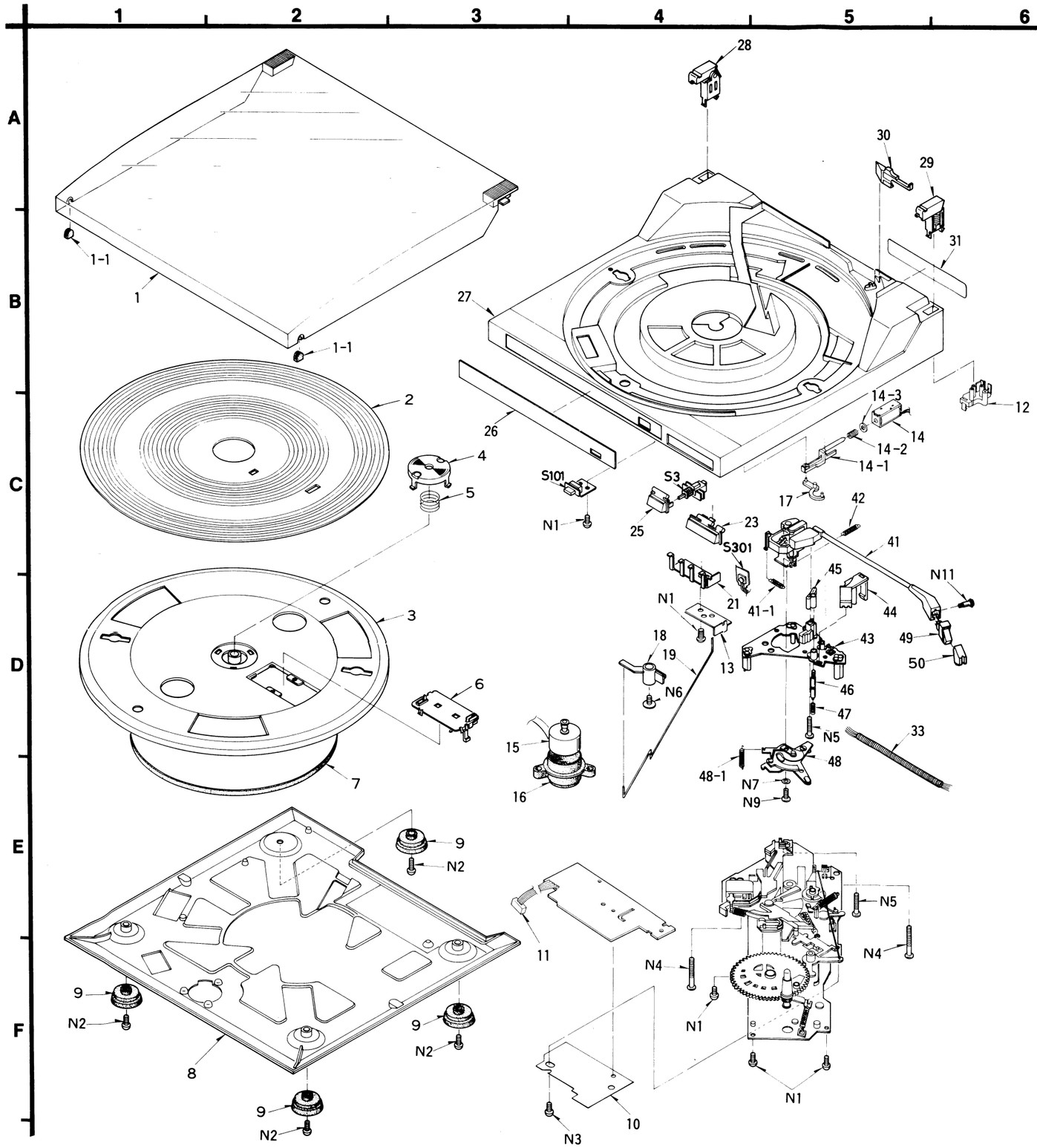
Ref. No.	Part. No.	Description
R204	ERDS2TJ104	Carbon, 1/4W, 100kΩ, ±5%
R205	ERDS2TJ102	Carbon, 1/4W, 1kΩ, ±5%
R206, 207	ERDS2TJ103	Carbon, 1/4W, 10kΩ, ±5%
R301	ERDS2TJ223	Carbon, 1/4W, 22kΩ, ±5%
R302	ERDS2TJ222	Carbon, 1/4W, 2.2kΩ, ±5%
R303	ERDS2TJ103	Carbon, 1/4W, 10kΩ, ±5%
R304	ERDS2TJ332	Carbon, 1/4W, 3.3kΩ, ±5%
R305	ERDS2TJ103	Carbon, 1/4W, 10kΩ, ±5%
R306	ERDS2TJ223	Carbon, 1/4W, 22kΩ, ±5%

Ref. No.	Part. No.	Description
R601, 602	ERDS2TJ222	Carbon, 1/4W, 2.2kΩ, ±5%
R603, 604	ERDS2TJ473	Carbon, 1/4W, 47kΩ, ±5%
R605, 606	ERDS2TJ103	Carbon, 1/4W, 10kΩ, ±5%
R607, 608	ERDS2TJ104	Carbon, 1/4W, 100kΩ, ±5%
R609, 610	ERDS2TJ102	Carbon, 1/4W, 1kΩ, ±5%
R611, 612	ERDS2TJ181	Carbon, 1/4W, 180Ω, ±5%
R613, 614	ERDS2TJ104	Carbon, 1/4W, 100kΩ, ±5%
R615, 616	ERDS2TJ102	Carbon, 1/4W, 1kΩ, ±5%
R617	ERDS2TJ681	Carbon, 1/4W, 680Ω, ±5%
CAPACITORS		
C1	ECQG1223KZ	Polyester, 100V, 0.022μF, ±10%
C2	ECEA1CU101	Electrolytic, 16V, 100μF
C201	ECEA0JU101	Electrolytic, 6.3V, 100μF
C202	ECEA1AU220	Electrolytic, 10V, 22μF
C301	ECKD1H473ZV	Ceramic, 50V, 0.047μF, $^{+80}_{-20}$ %
C302	ECEA0JU101	Electrolytic, 6.3V, 100μF
C601, 602	ECKD1H221KB	Ceramic, 50V, 220pF, ±10%
C603, 604	ECQG1H682KZ	Polyester, 50V, 0.0068μF, ±10%
C605, 606	ECQG1H273KZ	Polyester, 50V, 0.027μF, ±10%
C607, 608	ECKD1H102KB	Ceramic, 50V, 0.001μF, ±10%
C609, 610	ECEA16M10R	Electrolytic, 16V, 10μF
C611, 612	ECEA1AU470	Electrolytic, 10V, 47μF
C613, 614	ECEA1HUR47	Electrolytic, 50V, 0.47μF
C615	ECEA1AU470	Electrolytic, 10V, 47μF
C616	ECEA1CU101	Electrolytic, 16V, 100μF
CABINET AND CHASSIS PARTS		
1	SGDB50E00A	Dust Cover with Cushion Rubber (1)
1-1	SHGB5	Cushion Rubber (2)
2	SFTGN05N01	Turntable Mat (1)
3	SFTEN05N01	Turntable Platter (1)
4	SFWEN05N01	45 rpm Adaptor (1)
5	SFQAN05N01	Spring, Adaptor (1)
6	SFUMN05N04E	Record Size Detector (1)
7	SJY9008-1	Belt, Turntable Drive (1)
8	SKUB1-1	Bottom Board (1)
9	SFGAN05N01	Insulator (4)
10	SFUPN05N06	Shield Plate, Main Circuit Board (1)
11	SWKBJ16081	Connector (8 pin) (1)
12	SHRB35	Clamper, Lead Wire (1)
13	SUWB16	Bracket (1)

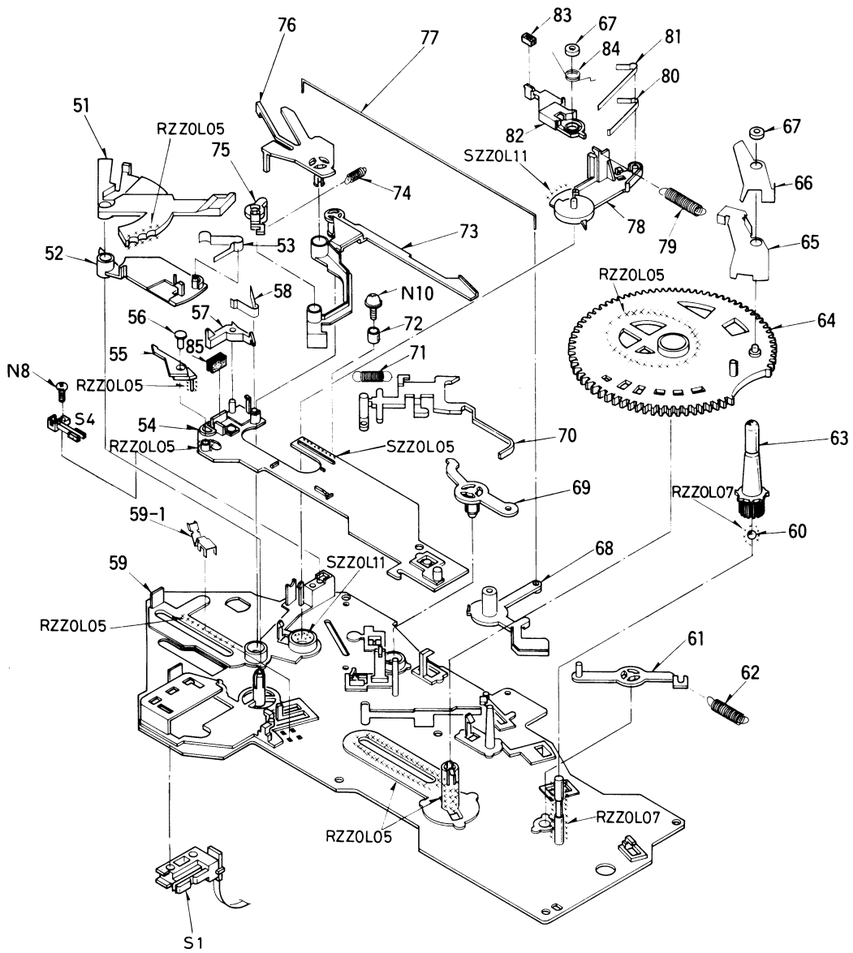
Ref. No.	Part. No.	Description
14	SJQB3E	Plunger Ass'y (1)
14-1	SHRB34	Cap (1)
14-2	SFQAQX3M51	Spring (1)
14-3	SFGHQX3M51	Rubber (1)
15	SMMLN3C-KN	Motor, Turntable Drive (1)
16	SHGB1	Cushion Rubber, Motor (1)
17	SHRB33	Rod, Plunger (1)
18	SHRB36	Lever, Cueing (1)
19	STZB11	Rod, Cueing (1)
21	SUWB12	Holder, Start/Stop Button (1)
23	SBCB40-0K	Button, Start/Stop (1)
25	SBCB50-0K	Button, Cueing (1)
26	SGXB150-0K2	Ornament Plate (1)
27	SKMB310-0K	Cabinet (1)
28	SFATN05N02E	Hinge, Left (1)
29	SFATN05N01E	Hinge, Right (1)
30	SKMB380-0K	Clamper, Tonearm (1)
31 [EG]	SGTB89	Name Plate (1)
31 [XA]	SGTB116	Name Plate (1)
31 [other]	SGTB88	Name Plate (1)
33	SFQAN05N05	Shield Spring, Lead Wire (1)
TONEARM PARTS		
41	SFAB9A	Tonearm Ass'y (1)
41-1	SUSB34-1	Spring, Stylus Pressure (1)
42	SFQHF01N06	Spring, Canceller (1)
43	SFUPN05N51E	Tonearm Base (1)
44	SKMB370-0K	Cover, Tonearm Base (1)
45	SFUMN05N60R	Tonearm Lifter (1)
46	SFXJN05N51	Shaft, Tonearm Lifter (1)
47	SUSB1	Spring, Shaft (1)
48	SFUPN05N56A	Plate, Pick-up Fixing (1)
48-1	SFQHN05N56	Spring, Pick-up Fixing Plate (1)
49	EPC-P24S	★Cartridge (1)
50	EPS-24CS	★Stylus (1)
AUTOMATIC MECHANISM PARTS		
51	SFUMN05N58	Index Plate (1)
52	SFUMN05N59	Sub Plate, Index (1)
53	SFQPB63M53	Spring, Index (1)
54	SFUBN05N52	Drive Plate (1)
55	SFUMN05N67	Sub Plate, Drive (1)
56	SFXJN05N52	Pin (1)
57	SFUMN05N51	Motive Plate (1)
58	SFQPN05N55-1	Spring, Motive Plate (1)
59	SFUKN05N53E	Mechanism Plate (1)
59-1	SFQPN05N54	Sub Plate, Index (1)
60	SFYB-5-32	Ball, Turntable Shaft (1)

Ref. No.	Part. No.	Description
61	SFUMN05N03	Setting Plate, Main Gear (1)
62	SFQHN05N58	Spring, Setting Plate (1)
63	SDWB1A	Turntable Shaft (1)
64	SFUGN05N52	Main Gear (1)
65	SFURZ15R51	Rink (A), Main Gear (1)
66	SFURN05N52	Rink (B), Main Gear (1)
67	SFUMZ15R61	Holder (2)
68	SFUMN05N53	Actuating Plate (1)
69	SFUMF01N23	Lever, Cueing (1)
70	SFUMN05N52	Lever, Start (1)
71	SFQHN05N52	Spring, Start Lever (1)
72	SFXBN05N52	Spacer (1)
73	SFUMN05N64	Lever, Switch (1)
74	SFQHN05N53	Spring, Sub Plate (1)
75	SFUMN05N65	Sub Plate, Switch Lever (1)
76	SFUMN05N55	Control Plate (1)
77	SFUZN05N51	Rod, Actuating (1)
78	SHRB4	Cam, Cueing (1)
79	SFQHF01N03	Spring Cam (1)
80	SFQPF01N03	Spring (1)
81	SFQPF01N07	Spring (1)
82	SFUMN05N66	Lever, Brake (1)
83	SFGZN05N51	Cushion Rubber (1)
84	SFQSN05N51	Spring, Brake Lever (1)
85	SFGZB63M51	Cushion Rubber (1)
SCREWS AND WASHER		
N1	XTV3+10J	Screw, ⊕3×10 (5)
N2	XTV3+10G	Screw, ⊕3×10 (4)
N3	XTV3+8J	Screw, ⊕3×8 (1)
N4	XTN3+35J	Screw, ⊕3×35 (2)
N5	XTN3+25J	Screw, ⊕3×25 (2)
N6	XTW3+10T	Screw, ⊕3×10 (1)
N7	XWE3A6BW	Washer (1)
N8	XTN17+4J	Screw, ⊕1.7×4 (1)
N9	XTN3+8J	Screw, ⊕3×8 (1)
N10	XTW3+8J	Screw, ⊕3×8 (1)
N11	SFPEV0Q601	Screw, Cartridge (1)
PACKING PARTS		
P1 [EF]	SPGB44	Carton Box (1)
P1 [other]	SPGB43	Carton Box (1)
P2	SFHHC01S01	Pad, Front (1)
P3	SFHHC01S02	Pad, Rear (1)
P4	SFHSN05N01E	Spacer, Dust Cover (1)
P5	SFHKN05N01	Clamper, Turntable Platter (2)
P6	SFYH45×60	Polyethylene Bag, Unit (1)
P7	SFHZC01N01	Clamper, Tonearm (1)
P8	SFHDC01N01	Pad, Turntable Mat (1)
P9	SFYF32A35	Polyethylene Bag, Turntable Mat (1)
P10	SFHDC01S02	Sheet, Dust Cover (1)

■ EXPLODED VIEW



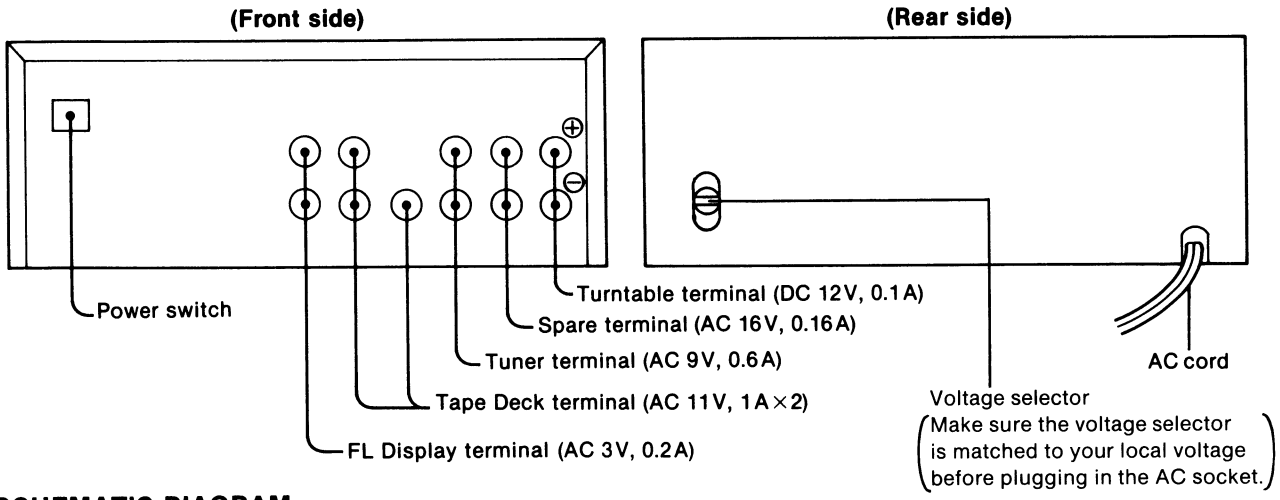
• **Mechanism parts**



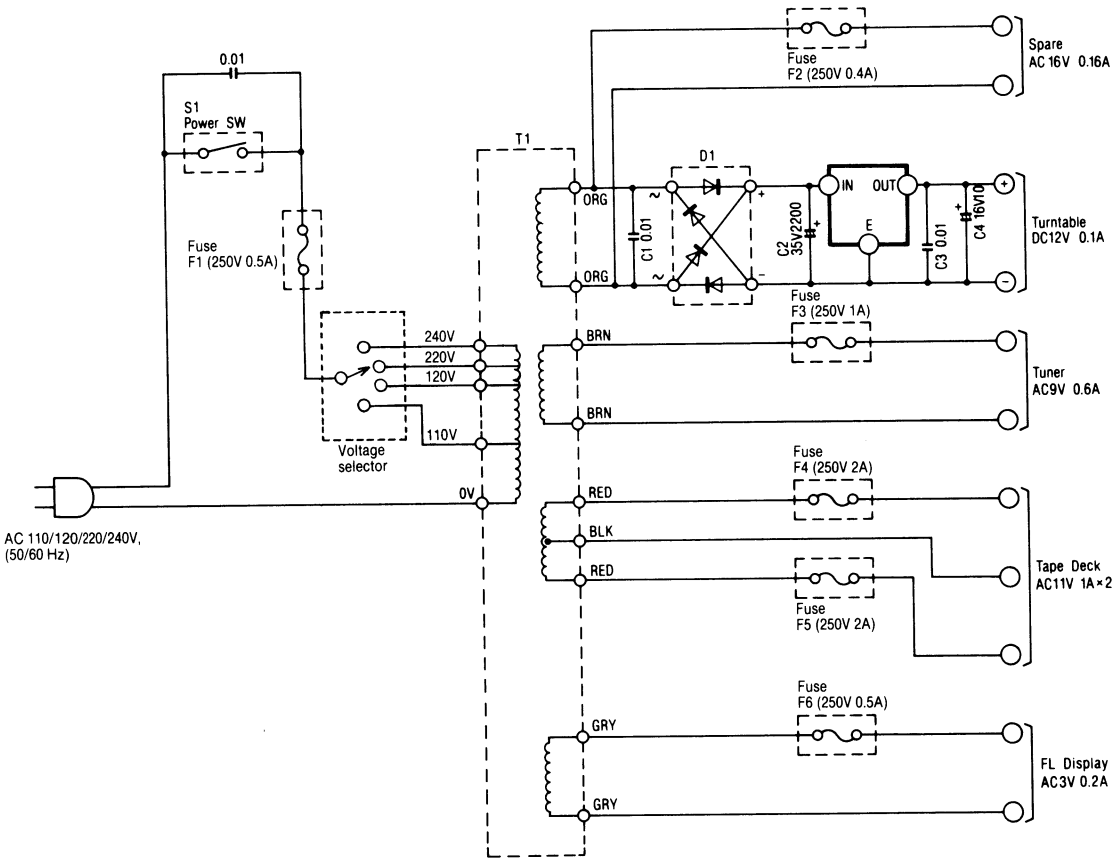
Note: When changing mechanism parts, apply the specified grease to the areas marked "XX" shown in the drawing.

■ INFORMATION FOR POWER SUPPLY JIG

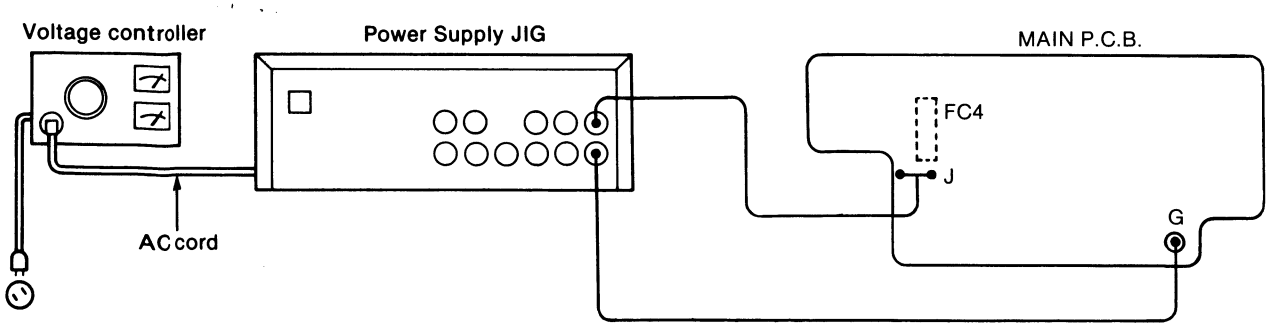
• LOCATION


(Front side)
(Rear side)
Power switch
Turntable terminal (DC 12V, 0.1A)
Spare terminal (AC 16V, 0.16A)
Tuner terminal (AC 9V, 0.6A)
Tape Deck terminal (AC 11V, 1A×2)
FL Display terminal (AC 3V, 0.2A)
AC cord
Voltage selector
(Make sure the voltage selector is matched to your local voltage before plugging in the AC socket.)

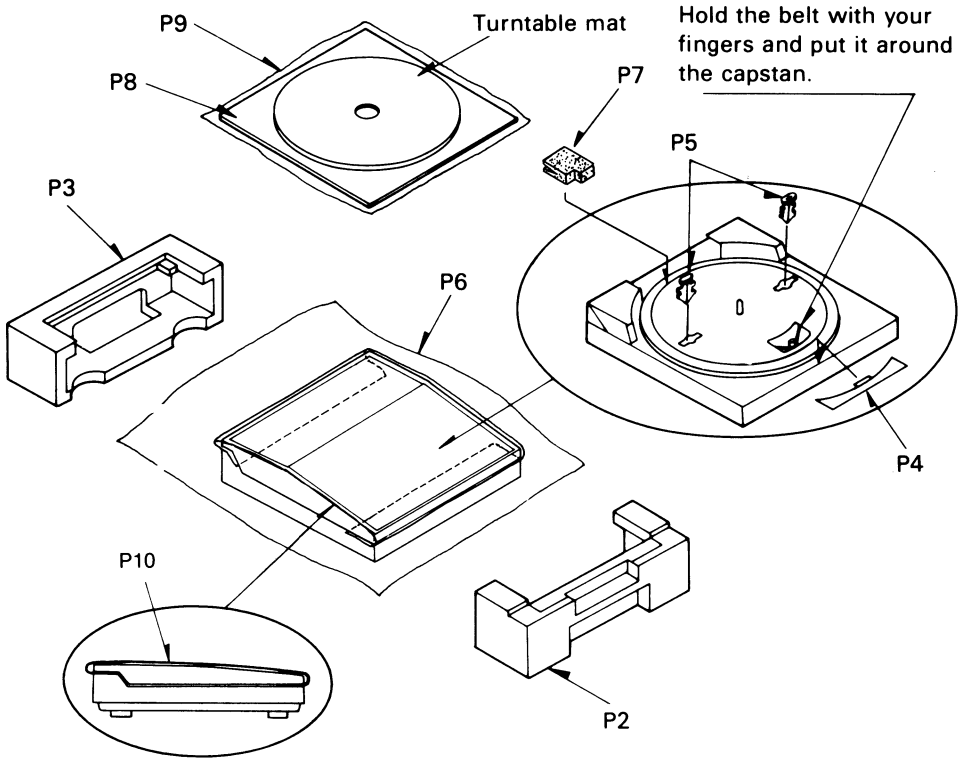
• SCHEMATIC DIAGRAM



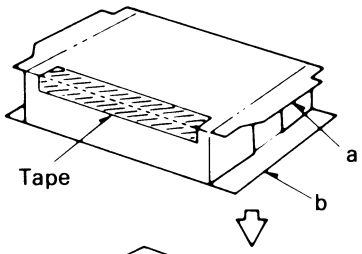
• HOW TO CONNECTION

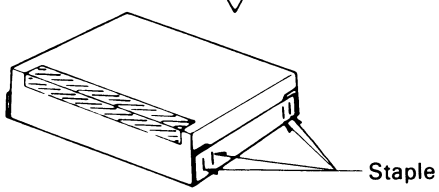


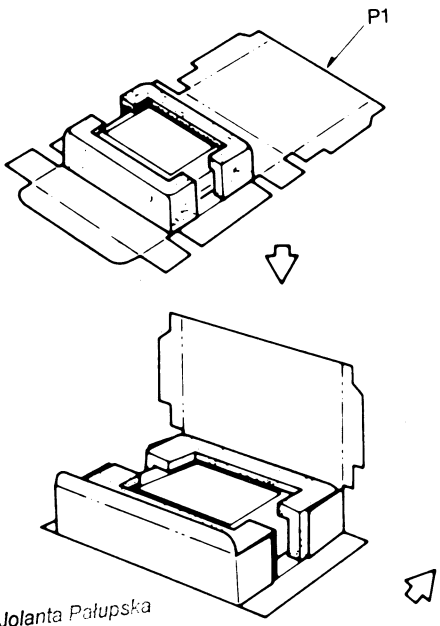
■ PACKING



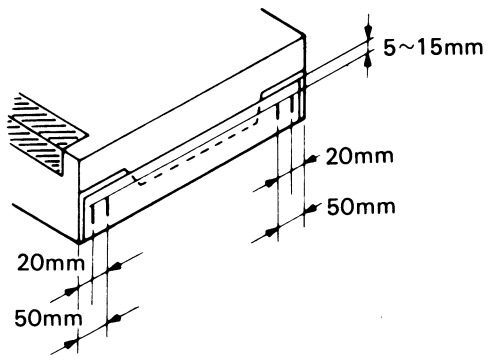
1. Place the unit (with cushions attached) as illustrated.
2. Fold the flaps according to the line marks.
3. Seal the top with adhesive tape.
   * Use gum tape or adhesive cloth tape of at least 50mm wide.
4. For the edges, first fold flap "a" and then flap "b", and staple. Remember to staple only flap "b". (Use 15 or 16mm staple.)







*Stapling positions are shown below.



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